

Work Order ID 108663

October-28-13 8:51:22 AM

108663

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Item ID: 647.9201

Revision ID:

Item Name: Upper Cutter Assembly

Start Date: 10/28/13 Start Qty: 10.00

Required Date: 10/29/13 Req'd Qty: 10.00

Reference: USE FOR LEAN TRAINING

Approvals: Process Plan:  Date:

QC: Date:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.9200

N/C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

120

Small Fab

Small Fab

Memo

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 2.

0.00

0.00

A/R RTV LOCTITE 598: _____
exp. date: _____

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Reference: USE FOR LEAN TRAINING

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P#
AND REV***

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

At 10-03-20
Closed at zero

Picklist Print

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Work Order ID: 108663

Parent Item: 647.9201

Parent Item Name: Upper Cutter Assembly

Start Date: 10/28/13

Required Date: 10/29/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

601.2045 RTV (LOCTITE 598)		Purchased	No				Each	231.0000		10			
-------------------------------	--	-----------	----	--	--	--	------	----------	--	----	--	--	--

Location	Loc Qty	Loc Code
ST520	72	
125540	72	
ST534	90	
125792	90	
ST540	69	
125637	69	

647.9411 Upper Deflector		Manufactured	No	B# 103415-wsp M2H			Each	0.0000		10			
647.9702 Upper Cutter Sub Assembly		Manufactured	No	B# 108661-wsp M2H			Each	0.0000		10			
MS21042L08 Nut		Purchased	No				Each	2,496.0000		30			

Location	Loc Qty	Loc Code
ST315	496	
122141	3	
122452	9	
122814	377	
123900	107	
ST505	2000	
125445	2000	

10 REWORK

122814 (12)

Picklist Print

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Parent Item: 647.9201

Parent Item Name: Upper Cutter Assembly

Start Date: 10/28/13

Required Date: 10/29/13

Start Qty: 10.00

Required Qty: 10.00

MS27039-08-19

Purchased

No

Each

1,972.0000

30

Screw

Location

Loc Qty

Loc Code

ST307

89

123525

89

ST308

40

m126474

40

ST309

643

125654

643

st510

1200

124309

1200

Each

14,256.000

60

NAS1149FN832P

Purchased

No

Washer

Location

Loc Qty

Loc Code

ST294

4280

123522

398

123900

3882

ST510a

9976

125268

9976

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Shop Packet Print

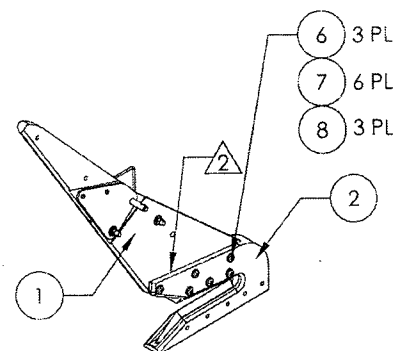
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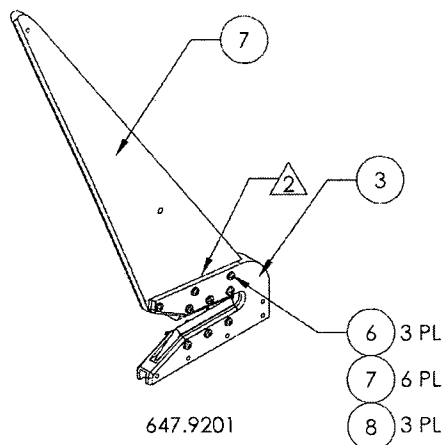
NOTES:

1. IDENTIFY IAW MPP - 120. LASER ETCH P/N AND REVISION, 12 PT. CENTURY GOTHIC.

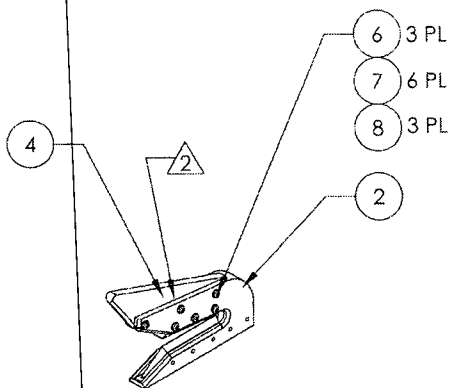
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 2, 3, 4, AND 7 UPON ASSEMBLY.



647.9203



647.9201



647.9202

A/R	A/R	A/R	9	601.2045	RTV	LOCTITE 598	
3	3	3	8	601.1541	LOCKNUT	MS21042108	
6	6	6	7	601.2764	WASHER	NAS1149FN832P	
3	3	3	6	601.2765	SCREW	MS27039-0819	
		1	7	647.9411	UPPER DEFLECTOR		
		1	4	647.9410	LOWER DEFLECTOR		
		1	3	647.9702	UPPER CUTTER SUB ASSY		
1	1		2	647.9701	LOWER CUTTER SUB ASSY		
1			1	647.9402	LOWER DEFLECTOR LONG ASSY		
				647.9203	LOWER CUTTER LONG ASSY		
				647.9202	LOWER CUTTER ASSY		
				647.9201	UPPER CUTTER ASSY		
.9203	.9202	.9201	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES			
647.8900				2608 TEMPLE HEIGHTS DR.			
				OCEANSIDE, CA. 92056-3512 (760)724-5300			
				CUTTER ASSY			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				3 PLACES DECIMALS ±.00			
				2 PLACES DECIMALS ±.01			
				ANGLES ±.5°			
				SCALE NONE			
				SHEET 1 OF 1			